



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-1
Job Sheet 196822



Part No: D3278-1

Job Qty: 60 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/21/19

Job Tracking No:

Due Date: 7/29/19

Created By: Marie Lajeunesse

Type: ~~Stock~~ *SOLD*

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	60 pcs		7/29/19	0.00	1.73	Bandsaw - 1		<i>Bm</i>
110	HAAS 5 Axis - B4B <i>KIA</i>	60 pcs		7/29/19	0.06	18.82	HAAS - 5 - B4B		
120	Outsource - 5 - Machining	60 pcs		7/29/19			MEM001-VC		<i>2019-06-26</i>
125	Packaging 2-1 - Receive - B4B	60 pcs		7/29/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		<i>DP JUL 22 2019</i>
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		



Container No: S193811



Part: D3278-1

Job No: 196822

Serial No/Batch: S193811

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/26/19

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
130	QC 6	60 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
140	Handfinish - 1-1 Chemical-B4B	60 pcs	7/29/19	0.00 0.57	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 -

DAS
61
9-89

★ JUL 23 2019

				B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)- B4B	60 pcs	7/29/19	0.00 0.45	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	60 pcs	7/29/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	60 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	

BL 19-7-24

THU 7-25-2019

→ 0.2 Bin: GA 119

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	60 pcs	7/29/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long
 Descriptions: 110 - (HAAS CNC vertical machine #5) 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1
 120 - (Outsource process - Machining)
 125 - (Receive & Inspect for Damage & Mat'l Certs)
 130 - (QC6- All purchased or subcontracted products)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:10 OVEN TEMPERATURE: 300° FINISH TIME: 10:15 MITSUBISHI
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location:) LOCATION : GA
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	13:0200 ft (217 ea)	100-Bandsaw - 1	19x5 110498 4x5 157420

Plex 6/21/19 10:53 AM Dart.lajeunesse.marie

MAT
used
13.000
3.9
9.1

Job Allocations

Operation	Component Part	Required	Inventor
100-Bandsaw - 1	M6061T6B1.000X02.000	13	31

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098	
2	Support	0.359inches ± 0.005	0.364 0.354	
3	Support	0.609inches ± 0.010	0.619 0.599	
4	Support	0.250inches ± 0.010	0.260 0.240	
5	Support	1.480inches ± 0.005	1.485 1.475	
6	Support	0.125inches ± 0.010	0.135 0.115	
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115	
8	Support	2.439inches ± 0.010	2.449 2.429	
9	Support	1.980inches ± 0.010	1.990 1.970	
10	Support	0.130inches ± 0.030	0.160 0.100	
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257	
12	Support	0.375inches ± 0.010	0.385 0.365	
13	Support	0.875inches ± 0.010	0.885 0.865	
14	Support	0.500inches ± 0.010	0.510 0.490	
15	Support	0.400inches ± 0.010	0.410 0.390	
16	Support	1.000inches ± 0.030	1.030 0.970	
17	Support	1.720inches ± 0.010	1.730 1.710	
18	Support	0.125inches ± 0.010	0.135 0.115	
19	Support	0.125inches ± 0.010	0.135 0.115	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043847



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043847

PO Date: 6/26/19

Due Date: 7/17/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-26

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196822	D3278-1	Support : Various STC's (Outsource process - Machining)	Firmed X60	-	7/17/19	60 pcs	0 pcs	60 pcs	\$46.94/pcs	\$2,816.40
2	196823	D3278-2	Support : Various STC's	Firmed X60	-	7/17/19	60 pcs	0 pcs	60 pcs	\$46.94/pcs	\$2,816.40
Grand Total:											\$5,632.80

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/26/19 3:48 PM Dart. Guerin/Kimberley

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25604
Shipment Date: 22-Jul-2019
Ship Via: Pick up at METEC
Order Number: 3962
Order Date: 06/26/2019

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB043847
Terms: Net 60 Days

----- Quantity -----									Job
Item	Open	Shipped	B/O	Canceled	Unit	Description		Revision	Number
1	60	60	0	0	EA	DART-D3278-1P Support, unpainted	DAS 61 9-89	C	3962-01
2	60	60	0	0	EA	DART-D3278-2P Support, unpainted		C	3962-02

RECEIVED
JUL 22 2019
DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.